

Date: Friday, 05/01/2007 11:31:35 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 212/205 HIGH FED X-TUBE ASSEMBLY
Job Number : 30192	
Estimate Number : 10254	
P.O. Number :	Part Number : D212664101
This Issue : 05/01/2007 S.O. No. :	Drawing Number : D212-664-141 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : B
Previous Run : 29505	Material :
Written By :	Due Date : 15/02/2007 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev:E 04.02.16 Reformat KJ/DS	
Est Rev:F 06-03-29 Remove Coments on Pick List JLM	

Additional Product

Job Number:



SLAP

Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-101CHG002

2.0

D6005128

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D6005-128	Crosstube	<u>25665</u>

Check OD = 2.750"; ID = 2.000"

MS 07/01/06 1

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA113

2-Turn first side as per Folio FA113

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141.

MS 07/01/06 1

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 07/01/07 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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Part Number: D212664101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA113

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141. MS 07/01/08 1

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 07/01/08 1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 07/01/08 1

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Remove sand and plugs

2-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141

MS 07/01/08 1

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

DP/JD 07 01-8

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-1-8

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DP/JD 7-1-8

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Job Number: 30192

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DD 7-2-6

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio FT015

EL/DP
7-2-6

14.0

QC5

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

7-2-6

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549

2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

81
07-02-28
P10

16.0

HAND FINISHING 1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: _____



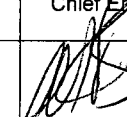
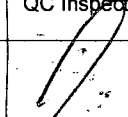
LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

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07-04-23 07-04-23	15.0	Holes were drilled .050" too low on the cuff, drilling was not bottomed out.	 07/09/19	Scrap part destroy.	 7-9-19	07-05-19	 07/09/19	 07-05-19

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Job Number: 30192

Part Number: D212664101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

20.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D212-664-141

21.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

22.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

23.0

D2856600

Abrasion Strip



Comment: Qty.: 0.7090 f(s)/Unit Total : 0.7090 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600-851 Abrasion Strip _____

24.0

D28931

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2893-1 Support _____

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Job Number: 30192

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

MS2192024

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-24 Clamp _____

26.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8581

2-Install supports and clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

29.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PLACARD

Batch: _____

30.0

AN635A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: _____

W/O:		WORK ORDER CHANGES					
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Job Number: 30192

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN636A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: _____

32.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: _____

33.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: _____

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-101

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 07-09-21

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	3092
Description: Crosstube Assembly (205/212/412 High Fwd)	Part Number:	D212-664-141
Inspection Dwg: D212-664-141 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	.063	✓			
	2.740	+0.005/-0.000	2.741	✓			
	5.097	+/-0.030	5.100	✓			
	2.304	+0.005/-0.000	2.302	✓			
	2.340	+0.005/-0.000	2.344	✓			
	2.398	+0.005/-0.000	2.402	✓			
	2.448	+0.005/-0.000	2.452	✓			
	2.498	+0.005/-0.000	2.503	✓			
	2.549	+0.005/-0.000	2.554	✓			
	2.599	+0.005/-0.000	2.604	✓			
	2.671	+0.005/-0.000	2.675	✓			
	2.701	+0.005/-0.000	2.706	✓			
SIDE B	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	.063	✓			
	2.740	+0.005/-0.000	2.744	✓			
	5.097	+/-0.030	5.100	✓			
	2.304	+0.005/-0.000	2.309	✓			
	2.340	+0.005/-0.000	2.345	✓			
	2.398	+0.005/-0.000	2.403	✓			
	2.448	+0.005/-0.000	2.453	✓			
	2.498	+0.005/-0.000	2.502	✓			
	2.549	+0.005/-0.000	2.554	✓			
	2.599	+0.005/-0.000	2.603	✓			
	2.671	+0.005/-0.000	2.675	✓			
	2.701	+0.005/-0.000	2.706	✓			
	126.51	+/-0.020	126.51	✓			

Measured by:	MS	Audited by:	JML	Prototype Approval:	N/A
Date:	07/01/06	Date:	07/01/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-101)	KJ/JLM	
B	06.03.15	Tolerance revised for 5.097 per Dwg Rev update	KJ/JLM	

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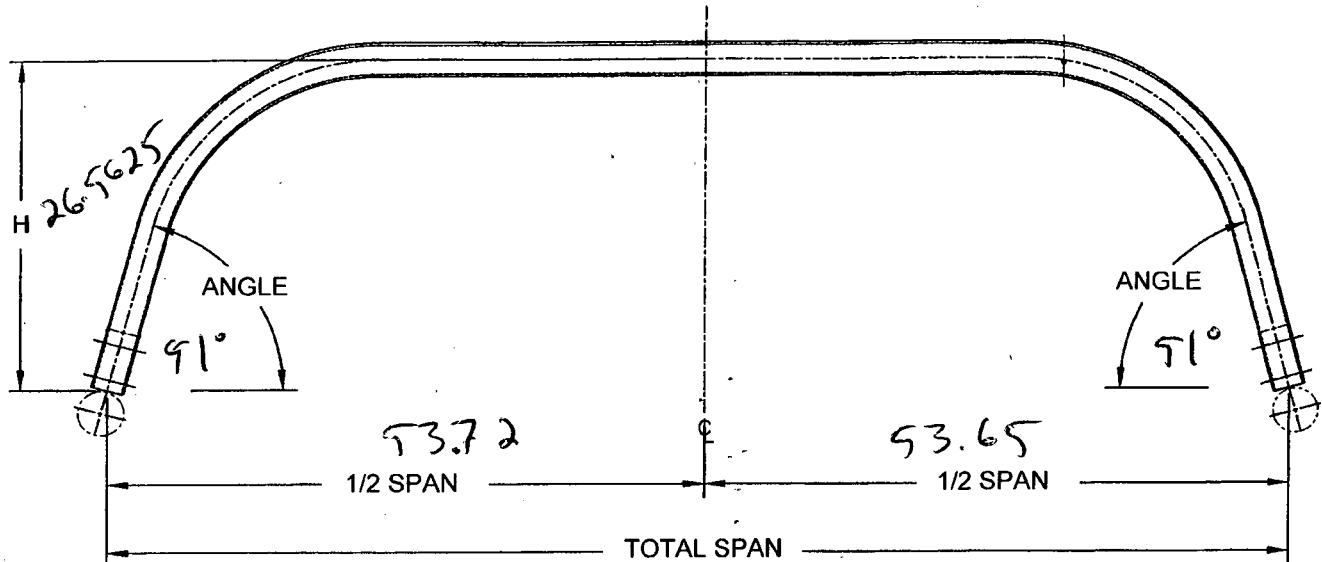
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NOTE: Date & initial all entries

Crosstube Bend Dimension Sheet



PART NUMBER: 0212-664-101

BATCH NUMBER: 30192

DRAWING: 0212-664-141 REVISION: B

H: 26.96

1/2 SPAN: 53.72

TOTAL SPAN: 107.44

ANGLE: 50

QC 15: 2

DATE: 07-28

QTY: 1

W/O:		WORK ORDER CHANGES					
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DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D212-664-141	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE XTUBE ASS'Y (205/212/412 HI FWD) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.06.09 [Signature]

WFO 30692

Qty	Part Number	Description
X	D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
1	D6005-128	CROSSTUBE
2	D2893-1	SUPPORT
2	D2856-600-851	ABRASION STRIP
4	MS21920-24	CLAMP

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.51±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 9) INSTALL D2856-600-851 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2893-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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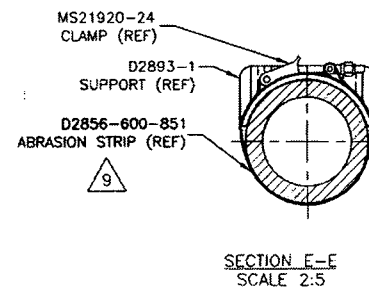
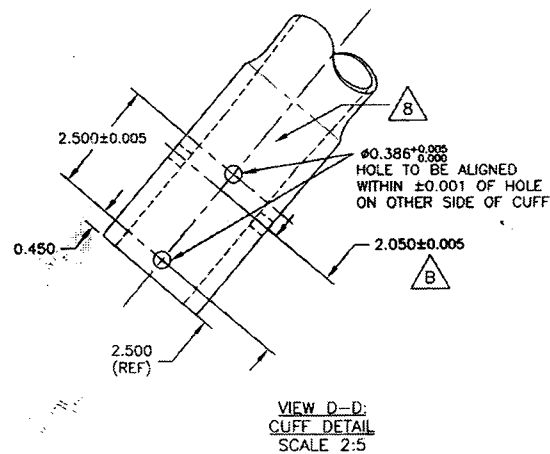
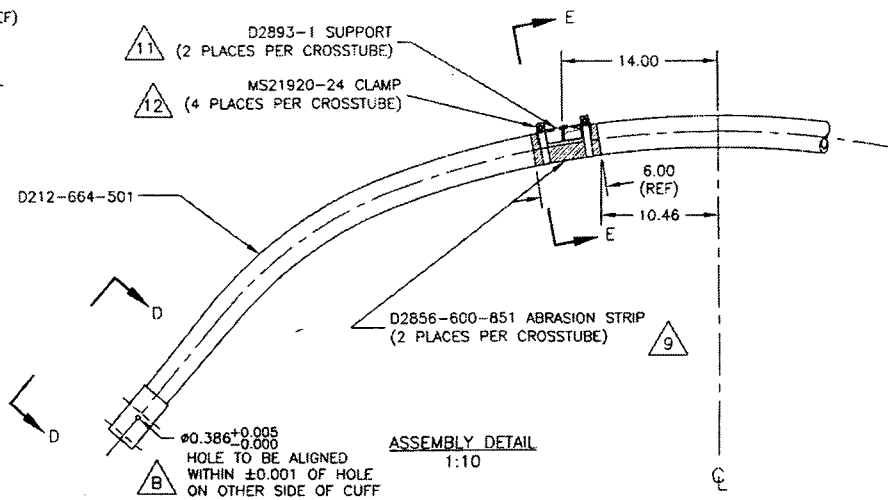
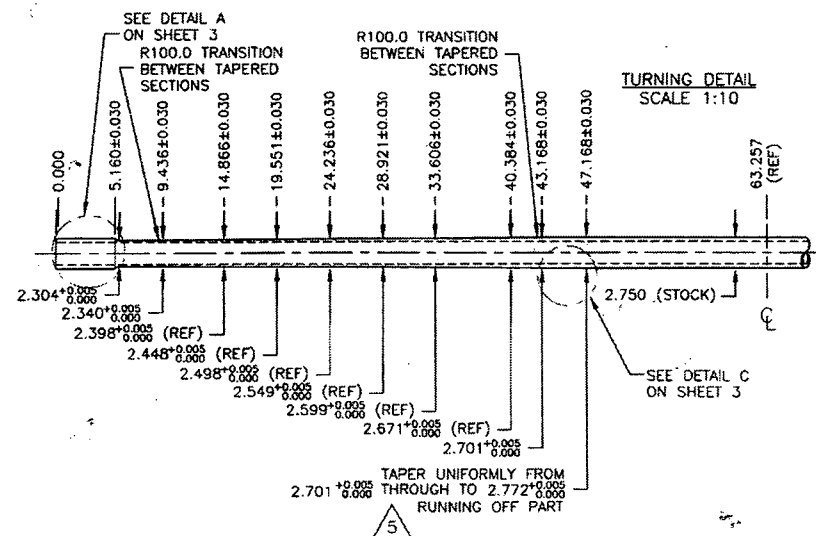
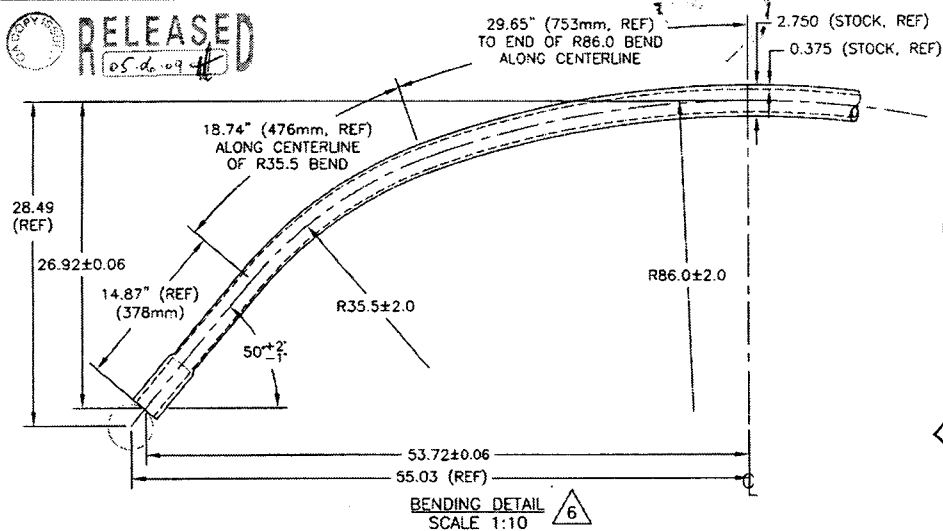
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RELEASED
05-06-09



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CHECKED	APPROVED	DRAWING NO.		REV. B	
DATE	TITLE	D212-664-141		SHEET 2 OF 3	
05.02.04	XTUBE ASS'Y (205/212/412 HI FWD)	SCALE		1:10	

W/O:		WORK ORDER CHANGES					
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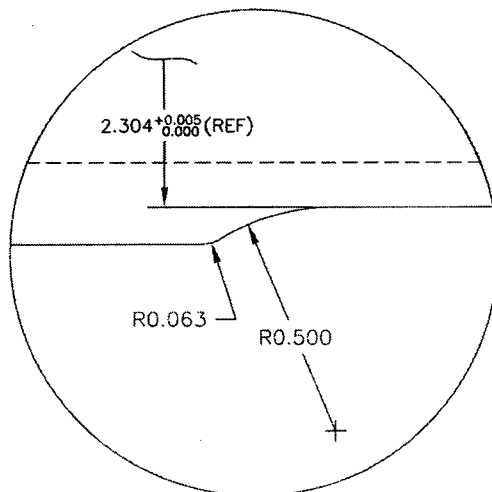
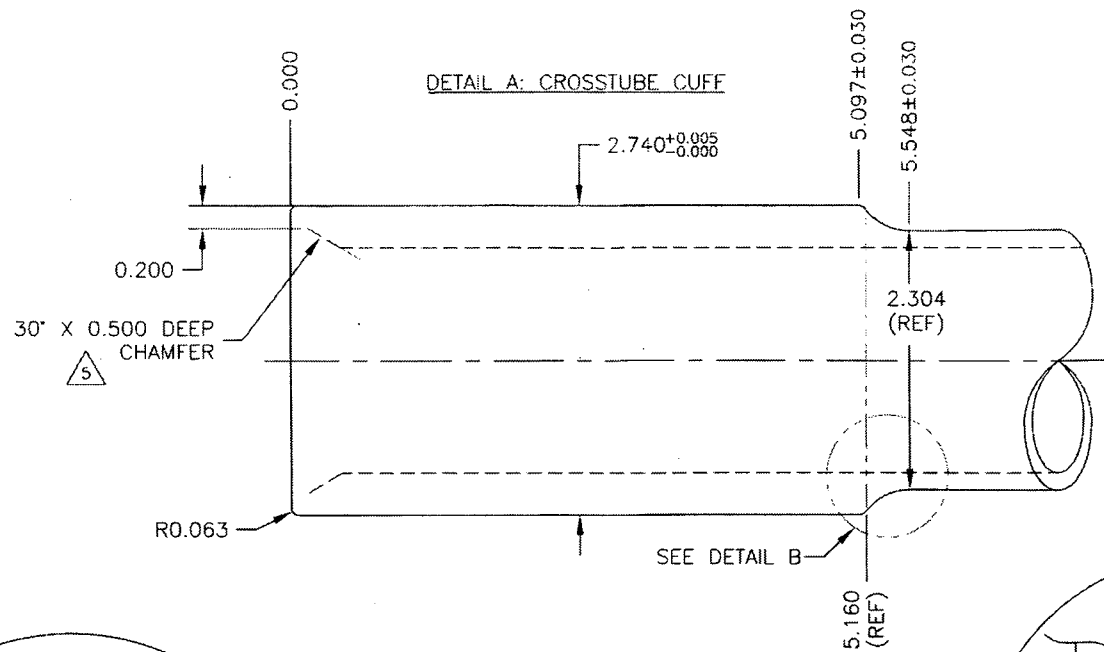
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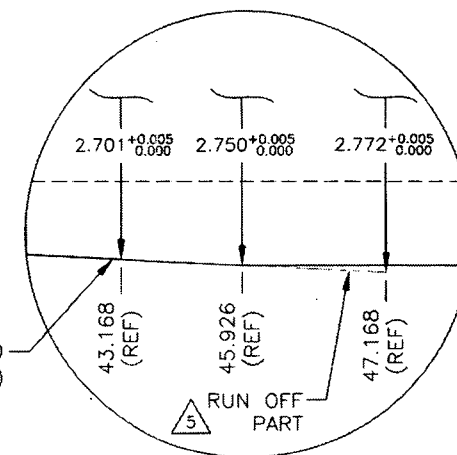


RELEASED
05 09 04



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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DESIGN	FW	DRAWN BY	FW	DART	DART AEROSPACE LTD. WARRICKSBOURNE, ONTARIO, CANADA
CHECKED	FW	APPROVED	FW	DRAWING NO.	REV. B
DATE	05.02.04	TITLE	D212-664-141	SHEET 3 OF 3	SCALE
			XTUBE ASS'Y (205/212/412 HI FWD)	1:1	

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